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Canada

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D4653-7

Job Sheet 201959



Part No: D4653-7

Job Qty: 60 pcs

Part Name: Fitting, Large



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/19

Job Tracking No:

Due Date: 11/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-06-11 JLM VERIFIED BY:DD

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 100   | Doosan - 1                  | 60 pcs | 11/8/19    | 11/8/19  | 0.26      | 11.09   | Doosan - 1            |           |             |
| 120   | QC 8                        | 60 pcs | 11/8/19    | 11/8/19  | 0.00      | 0.00    | QC 8 - 12             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 14             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 17             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 20             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 25             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 3              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 32             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 33             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 35             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 39             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 4              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 44             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 45             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 49             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 58             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 8              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 9              |           |             |
|       |                             |        |            |          |           |         | QC 8 - 68             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 67             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 1 (A)          |           |             |
|       |                             |        |            |          |           |         | QC 8 - 47             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 40             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 52             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 23             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 57             |           | SBL 19/4/10 |
|       |                             |        |            |          |           |         | QC 8 - 76             |           |             |
|       |                             |        |            |          |           |         | QC 8 - 61             |           |             |
| 130   | Packaging 3-1 - Stock - B4B | 60 pcs | 11/8/19    | 11/8/19  | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |             |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |             |



Container No: S232444



Part: D4653-7

Job No: 201959

Serial No/Batch: S232444

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/15/19

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|     |            |        |         |                        |                 |
|-----|------------|--------|---------|------------------------|-----------------|
|     |            |        |         | Packaging 3 - 4 - B4B  |                 |
|     |            |        |         | Packaging 3 - 5 - B4B  |                 |
|     |            |        |         | Packaging 3 - 6 - B4B  |                 |
|     |            |        |         | Packaging 3 - 7 - B4B  |                 |
|     |            |        |         | Packaging 3 - 8 - B4B  |                 |
|     |            |        |         | Packaging 3 - 9 - B4B  |                 |
|     |            |        |         | Packaging 3 - 10 - B4B |                 |
|     |            |        |         | Packaging 3 - 11 - B4B |                 |
|     |            |        |         | Packaging 3 - 12 - B4B | Q               |
|     |            |        |         | Packaging 3 - 13 - B4B |                 |
|     |            |        |         | Packaging 3 - 14 - B4B |                 |
|     |            |        |         | Packaging 3 - 15 - B4B |                 |
|     |            |        |         | Packaging 3 - 16 - B4B |                 |
|     |            |        |         | Packaging 3 - 17 - B4B |                 |
|     |            |        |         | Packaging 3 - 18 - B4B |                 |
|     |            |        |         | Packaging 3 - 19 - B4B |                 |
|     |            |        |         | Packaging 3 - 20 - B4B |                 |
|     |            |        |         | Packaging 3 - 21 - B4B |                 |
|     |            |        |         | Packaging 3 - 22 - B4B |                 |
|     |            |        |         | Packaging 3 - 23 - B4B |                 |
|     |            |        |         | Packaging 3 - 24 - B4B |                 |
|     |            |        |         | Packaging 3 - 25 - B4B |                 |
|     |            |        |         | Packaging 3 - 26 - B4B |                 |
|     |            |        |         | Packaging 3 - 27 - B4B |                 |
|     |            |        |         | Packaging 3 - 28 - B4B |                 |
|     |            |        |         | Packaging 3 - 29 - B4B |                 |
|     |            |        |         | Packaging 3 - 30 - B4B |                 |
|     |            |        |         | Packaging 3 - 31 - B4B |                 |
|     |            |        |         | Packaging 3 - 32 - B4B |                 |
|     |            |        |         | Packaging 3 - 33 - B4B |                 |
|     |            |        |         | Packaging 3 - 34 - B4B |                 |
|     |            |        |         | Packaging 3 - 35 - B4B |                 |
|     |            |        |         | Packaging 3 - 36 - B4B |                 |
| 140 | QC 21 - SA | 60 pcs | 11/8/19 | 0.00 0.00              | QC 21 - SA - 21 |
|     |            |        |         |                        | QC 21 - SA - 70 |
|     |            |        |         |                        | QC 21 - SA - 53 |

DAS  
21  
9.00

NOV 18 2019

Part Op 120 - (QC8- Inspect parts - second check)  
 Descriptions: 130 - (Identify as per dwg & Stock Location: WACO)  
 140 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item   | Component Name  | Quantity             | Operation      | Container |
|---------------|-----------------|----------------------|----------------|-----------|
| M6061T6R1.000 | Round Bar 1.00" | 10.5000 ft (.175 ea) | 100-Doosan - 1 | 229480    |

## Job Allocations

| Operation      | Component Part | Required | Inventory | Allocated |
|----------------|----------------|----------|-----------|-----------|
| 100-Doosan - 1 | M6061T6R1.000  | 11       | 46        | 0         |

| Part Specifications |               |                                |                  |                 |                  |
|---------------------|---------------|--------------------------------|------------------|-----------------|------------------|
| Spec No             | Description   | Target/Tolerance               | Limits           | Type            | Special Comments |
| 1                   | Large Fitting | 1.380Inches $\pm$ 0.030        | 1.410<br>1.350   | 1.378           |                  |
| 2                   | Large Fitting | 0.250Inches $\pm$ 0.010        | 0.260<br>0.240   | 0.251           |                  |
| 3                   | Large Fitting | 45.000Degrees $\pm$ 0.500      | 45.500<br>44.500 | 45 Angle        |                  |
| 4                   | Large Fitting | 0.0940inches $\pm$ 0.0300      | 0.1240<br>0.0640 | 0.097 Radius    |                  |
| 5                   | Large Fitting | 2.120Inches $\pm$ 0.030        | 2.150<br>2.090   | 2.115           | * before char F  |
| 6                   | Large Fitting | 0.825Inches $\pm$ 0.010        | 0.835<br>0.815   | 0.824 Diameter  |                  |
| 7                   | Large Fitting | 0.547Inches $\pm$ 0.010        | 0.557<br>0.537   | 0.55 Diameter   |                  |
| 8                   | Large Fitting | 0.0990inches $\pm$ 0.0100      | 0.1090<br>0.0890 | 0.095           |                  |
| 9                   | Large Fitting | 0.745Inches + 0.000<br>- 0.005 | 0.745<br>0.740   | 0.7425 Diameter |                  |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. \_\_\_\_\_

Job: \_\_\_\_\_

Part No. \_\_\_\_\_

### DISPOSITION

Rework ☐  
Scrap ☐  
Use-as-is ☐

### DEPARTMENT/PROCESS

Skid-tube ☐  
Machining ☐  
Large Fab ☐

Cross tube ☐  
Small Fab ☐  
Finishing ☐

Eng. (Non-AW) ☐  
Prod. Eng. Coord. ☐  
Rec/Store/Packaging ☐

Engineering ☐  
Water Jet ☐  
Supplier ☐  
Quality ☐

Date: \_\_\_\_\_

Sequence #: \_\_\_\_\_

QTY Affected: \_\_\_\_\_

MRB (QS1042)

### Description Work Order Deviation

### Disposition

Completed By \_\_\_\_\_

Lead hand / Supervisor \_\_\_\_\_

QC / QA Coordinator \_\_\_\_\_

### Root Cause

Operator ☐  
Manufacturing Process ☐  
Equip/Tooling ☐  
Handling/Preservation ☐  
Material ☐  
Product Improvement ☐  
Process Improvement ☐  
Human Factors ☐

Pressure/Forced ☐  
Bending ☐  
Crushing ☐  
Cracks ☐  
Crimp/Kink/Ripple/Wave/Twist ☐  
Marks/Chatter ☐  
Mislabeled ☐

Other/Details: \_\_\_\_\_

### FAULT CATEGORY

Contamination ☐  
Misaligned/off center ☐  
BOM/Route ☐  
Broken/Damage/Defect ☐  
Incomplete/Unclear Instructions ☐  
Drill Holes ☐  
Fit/Function ☐

Power Loss/Surge ☐  
Folio/Program ☐  
Grain Direction ☐  
Weld ☐  
Wrong Stock Pulled ☐  
Out of Sequence ☐  
Off-set/Set-up ☐

Positioned Wrong ☐  
Outside Tolerance ☐  
Drawing ☐  
Finish ☐  
Part Lost/Missing ☐  
Misread ☐